

Date: Monday, 10/16/2006 2:01:39 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 29012  
 Estimate Number : 10330  
 P.O. Number : N/A Part Number : D2746  
 This Issue : 10/16/2006 S.O. No. : N/A Drawing Number : D2746 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C  
 Previous Run : 28257 Material : N/A Due Date : 11/15/2006 Qty: 39 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: D 02.10.24 Re-format KJ  
 Est Rev: E 06-03-21 as Per Rev C JLM  
 Est Rev: F 06-06-12 Now On Waterjet JLM

## Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

mf. 07-01-17

2.0 M1010S20GA 1010/1025/A21/6aA SHEET

Comment: Qty.: 0.4263 sf(s)/Unit Total: 12.7890 sf(s)

1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: M103210

SAN 07:01:15

(39)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07:01:15

(39)

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

07/01/15 (39)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

SBS 07/01/17 39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 07/10/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:39 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29012

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB 07/01/17 (39)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/17 (39)

8.0

POWDER COATING

POWDER COATING



M 101 601



(39x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.H/FC 07/01/18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

yl 07/01/18 x 39

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP20

yl 07/01/18 x 39

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(39) 07/01/18

Job Completion



u 0701.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

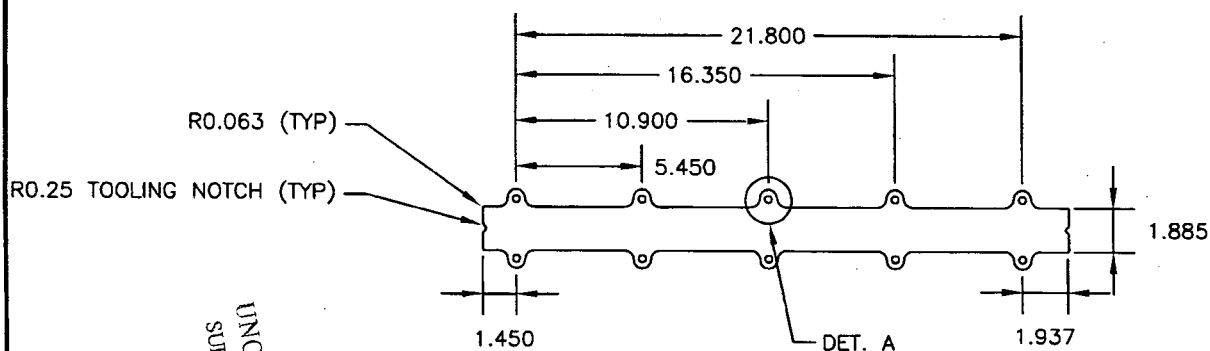


**DART**

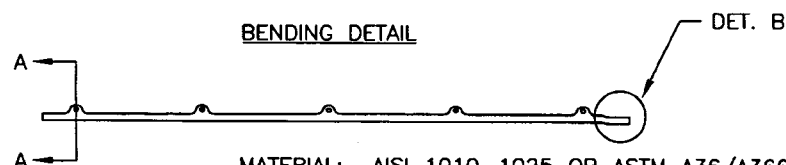
RELEASED  
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
P41	P41	DRAWING NO.	D2746	REV. C
CHECKED	APPROVED	SHEET 1 OF 1		
DATE	06.01.12	TITLE	WEARSHOE	SCALE
				1:8
A	98.04.16	NEW ISSUE		
B	98.08.18	RE-DESIGN		
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT		

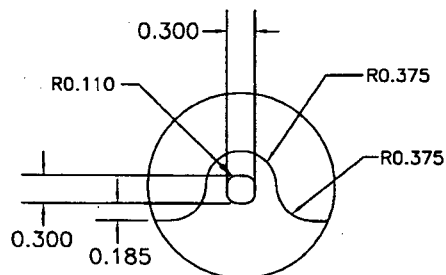
FLAT PATTERN



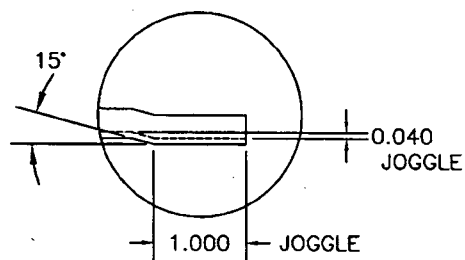
BENDING DETAIL



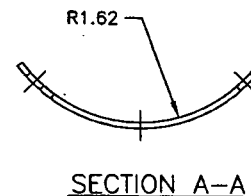
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



**NOTES**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

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